

Work Order ID 51777

Thursday, September 03, 2009 8:09:20 AM



Page 1

Item ID: D135-751-011

Accept



Setup Start



Revision ID: C

Stop



Item Name: Skidtube Installation

Start Date: 9/3/2009 Start Qty: 1.00

Cust Item ID:

Required Date: 9/17/2009 Req'd Qty: 1.00

Customer:

Reference:

Approvals:

Process Plan:

RL MT

Date:

09-03

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run Start



Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D3507	Rev C								

100

0.00



DOCUMENT CONTROL

DC

Memo

0.00

Document Control

Photocopy bluefile & type labels per PPP D135-751-011

CHG001

7

110

0.00



Skidtubes

Skidtubes

Memo

0.00

Skidtubes

1-Determine square end of tube and deburr

2-Drill #30 pilot holes using DT8678. Do not open holes.

3- Deburr holes.

9-9-14

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Start Date: 9/3/2009 Start Qty: 1.00

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Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run HoursDraw
NumberDraw
Rev.Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

120

0.00



CNC Bend 1

BENDING MACHINE - SKIDTUBES

Memo

0.00

CNC Delta 100 Bender

- Bend tube as per program on CNC Bender and Dwg D3507. Use 5/16" locator pin on buggy "A".

- cut Fwd End of tube as per dwg D3507

9-9-14

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Run Start

Stop

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	----------------	--------------	--------------	---------------	---------------	------------------	----------------

130

0.00



Skidtubes

Skidtubes

Memo

0.00

1-Cut Fwd end of the tube using DT8185

N/A

2-Cut Aft end at VC using DT8185

as per dwg D3507

3-Debur ends

4-Drill Aft & Fwd Cap holes using DT8678 & DT8901

5-Locate DT8870 & Drill Ground wire hole on top of Tube.

6-Locate DT8870 with 3/16cleco in Ground wire hole ,then Pilot Drill all X-Bolt holes using 3/16" drill.****DO NOT OPEN AFT CAP HOLES*****

7-Drill pilot holes for wearplates using Dt8868,Use DT8892 FOR REAR WEARPLATE HOLES.

8-Open six rear wearplate holes using DT8892.Open holes to 0.297"

9- Section G-G holes must be laid out manually, open to #30.

10- Drill holes section G-G (DT9431)

11-Open Aft & Fwd Cap holes using .208" drill.

12-Bore out aft end of tube as per Dwg D3507 & Detail "B".

13-Open ground wire hole .297" section E-E

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Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run HoursDraw
NumberDraw
Rev.Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

160

QC3- Inspect Part Finish

0.00



QC

Memo

0.00

Quality Control

G.N 09 - 09 - 16 0

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Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run HoursDraw
NumberDraw
Rev.Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

170

0.00



Skidtubes

Skidtubes

Memo

0.00

1-Open X-Bolt holes to .375"(2Places) & .500"(2Places) as per Dwg D3507 and Detail "F"

2-Counter Sink X-BOLT holes as per Dwg D3507

3-Deburr and blow out chips from inside of tube.

4-Bond web as per Dwg D3507 & QSI 015

A/R 241 Sike Flex Batch: M112391
Exp Date: 2010/02

5-Weld x-bolt (D3504-1/-3) spacers as per Dwg D3507 and Detail C-C & D-D.

A/R AL ROD Batch: M111477

6-Grind welds flush

7-Drill Rivet Holes as per Dwg D3507 Using Dt8871A&B

8-Deburr Rivet holes.

DP
9-9-17

DP 9-9-28

BE 09/09/06

DP 9-10-6

DP 9-10-6

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Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run HoursDraw
NumberDraw
Rev.Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

180

QC10- Inspect visual per QSI004- ground welds

0.00

⇒ Sorkolac

QC

Memo

0.00

Quality Control

+C

/

190

Skidtubes

0.00

Skidtubes

Memo

0.00

Skidtubes

1-Rivet D3506-1/-3 as per Dwg D3507.

9-10-8

200

QC5- Inspect part completeness to step on W/O

0.00

2) S 6/10/08

QC

Memo

0.00

Quality Control

+C

/

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QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run HoursDraw
NumberDraw
Rev.Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

210



HandFinish

Hand Finishing

Pressure Wash per QSI005 4.3

Memo

0.00

0.00

= 11 09/10/09

(X1) 0

220



Powdercoat

Powder Coating

White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum

11 109091

Memo

START TIME: 10:25
OVEN TEMPERATURE: 320°
FINISH TIME: 10:05

0.00

0.00

11 09-10-9

(1) .

230



QC

Quality Control

QC3- Inspect Part Finish

Memo

0.00

0.00

= 11 09/10/13

(X1) 0

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Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
240 HandFinish Hand Finishing	HandFinishing Memo Install Wearplate &Ground Wire inserts as per Dwg D3507.	0.00 0.00							
250 QC Quality Control	QC5- Inspect part completeness to step on W/O Memo Inspect Inserts	0.00 0.00							

BR 09-10-13 ①

① 09-10-16

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Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start

Stop

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

260



HandFinish

Hand Finishing

HandFinishing

Memo

1-Inspect for Foreign objects

2-Install Fwd & Aft caps as per Dwg D3507 And Detail "A" & "B"

A/R 241 Sika Flex Batch: M112 391
Exp Date: 10/20

3-Install Wearplates as per Dwg D3507 ,

Note:Install (1) Bolt and (1) washer on Ground Wire insert on top of tube
Do not Install Scews where indicated on Dwg(Note #6)

A/R 241 Sika Flex Batch: M112 391
Exp Date: 10/20

4-Install Plug assemblys as per Dwg D3507.

5- Wing Walk as per Dwg D3507 and QSI 005 4.4

M112 106

270



QC

Quality Control

QC5- Inspect part completeness to step on W/O

Memo

0.00

0.00

2502/10/14

PR 02-10-13.

(+)

4

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Cust Item ID:

Required Date: 9/17/2009 Req'd Qty: 1.00



Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start

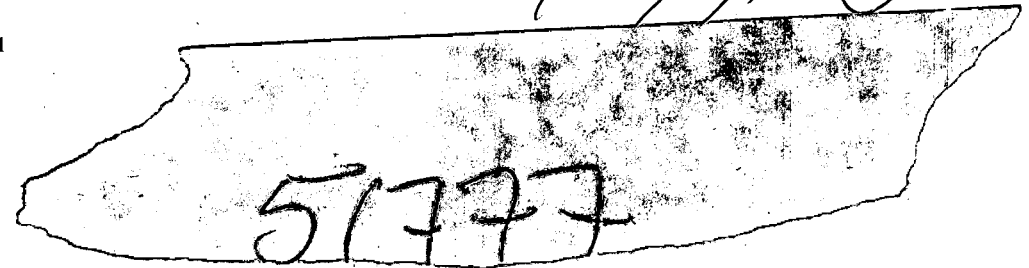


QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
280 	Pick Kit	0.00							
Packaging Packaging	Memo	0.00							<i>9/15/09</i> (1)
290 	QC4- 100% Inspect kits for completeness	0.00							
QC Quality Control	Memo	0.00							<i>1</i> <i>9/15/09</i>
300 	Packaging	0.00							
Packaging Packaging	Memo	0.00							<i>9/16/09</i> (1)
Identify and pack for shipping as per PPP D135-751-011									
Location: <i>B</i>									
PPP Rev: <i>B</i>									



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Start Date: 9/3/2009 Start Qty: 1.00

Required Date: 9/17/2009 Req'd Qty: 1.00

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run HoursDraw
NumberDraw
Rev.Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

310

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

09/10/19

PL 04 09-10-16

Picklist Print

Thursday, September 03, 2009 8:11:22 AM

Page 1

Work Order ID: 51777

Parent Item: D135-751-011RevC

Parent Item Name: Skidtube Installation


Comments:

Start Date: 9/3/2009

Required Date: 9/17/2009

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
D2962-150RevA		Manufactured	No			110	Each	43.0000	1.0000			
												
3.540 Outer Tube, Extrut												

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST

43

28672

43

D3504-1RevC

Manufactured

No

170

Each

15.0000

2.0000



Crossbolt Spacer

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST

15

31234

15

D3504-3RevC

Manufactured

No

170

Each

16.0000

1.0000



Crossbolt Spacer

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST

16

31232

16

1

2

1

BE 09/09/06

BE 09/09/06

Picklist Print

Page 2

Thursday, September 03, 2009 8:11:22 AM

Work Order ID: 51.777



Parent Item: D135-751-011RevC



Parent Item Name: Skidtube Installation

Start Date: 9/3/2009

Required Date: 9/17/2009

Comments:

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
D3504-5RevC 		Manufactured	No			170	Each	10.0000	2.0000			
Crossbolt Spacer												

Warehouse Loc Qty Loc Code
Location

Main Warehouse

ST

10

36181

10

D3505-1RevA

Manufactured

No

170

Each

2.0000

1.0000



Web



2 RE 09/09/06

Warehouse Loc Qty Loc Code
Location

Main Warehouse

ST

2

51708

2

D3506-3RevA

Manufactured

No

170

Each

14.0000

2.0000



Doubler



D-52171 MB 09-09-28

Warehouse Loc Qty Loc Code
Location

Main Warehouse

LG

14

50563

14

9-10-8

2

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Page 2

Picklist Print

Page 3

Thursday, September 03, 2009 8:11:22 AM

Work Order ID: 51777



Parent Item: D135-751-011RevC



Parent Item Name: Skidtube Installation

Start Date: 9/3/2009

Required Date: 9/17/2009

Comments:

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
ALS7-1032-130		Purchased	No			240	Each	3,406.000	38.0000			
Insert												

Warehouse Loc Qty Loc Code

Location

Main Warehouse

ST

3406

105855

16

108606

52

111529

1488

111779

1850

38 BR 09-10-13

MS20601-AD4W3

Purchased

No



240

Each

270.0000

12.0000

Rivet



Warehouse Loc Qty Loc Code

Location

Main Warehouse

ST

270

107823

3

111359

267

12

9-10-08

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Start Date: 9/3/2009

Required Date: 9/17/2009

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
ALS4-1032-225		Purchased	No			260	Each	8,785.000	1.0000			



Insert

Warehouse Loc Qty Loc Code

Location

Main Warehouse

ST

8785

107441

16

110768 ✓

8769

AN3C4A

Purchased

No

260

Each

210.0000

31.0000



BOLT

Warehouse Loc Qty Loc Code

Location

Main Warehouse

FP

-44

112314

-44

Main Warehouse

ST

254

112082

14

~~112314~~

240

112720

1 BR 09-10-13.

31 FR 09-10-13.

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Required Date: 9/17/2009

Comments:

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Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
AN3C5A		Purchased	No			260	Each	646.0000	2.0000			
Bolt												

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST

646

111424

8

111707

338

112314 ✓

200

112489

100

2 Bk 09-10-13.

AN526C1032R10

Purchased

No

260

Each

594.0000

2.0000



Screw

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST

594

108062 ✓

135

108167

35

110049

424

2 Bk 09-10-13

Picklist Print

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Comments:

Start Date: 9/3/2009

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Start Qty: 1.00

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Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
AN960C10L  washer		Purchased	No			260	Each	2,500.000	33.0000			

Warehouse Loc Qty Loc Code

Location

OFFSHORE

FG 100

103585 100

Main Warehouse

FP -44

112116 -44

Main Warehouse

ST 2444

112116 2444

33 B202-10-13.

D2965-3RevB

Manufactured No

260

Each

6.0000

1.0000



Cap

Warehouse Loc Qty Loc Code

Location

Main Warehouse

ST 6

50560 6

52282

1 B202-10-13.

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Required Date: 9/17/2009

Comments:

Start Qty: 1.00

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Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
D2965RevB		Manufactured	No			260	Each	17.0000	1.0000			
Cap, 105 Skidtube												

Warehouse Loc Qty Loc Code
Location

Main Warehouse

FP4 6

50609 ✓ 2

50924 4

Main Warehouse

ST 11

43288 6

46800 5

1 BR 09-10-13.

D3492-041RevC Manufactured No



Plug Assembly

260 Each 3.0000 4.0000



Warehouse Loc Qty Loc Code
Location

Main Warehouse

ST 51584 3

43816 3

4 BR 09-10-13.

D3492-043RevC Manufactured No



Plug Assembly

260 Each 0.0000 4.0000



51642

4 BR 09-10-13.

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D3492-047RevC		Manufactured	No			260	Each	56.0000	2.0000			

Plug Assembly

Warehouse
Location

Loc Qty

Loc Code

Main Warehouse

ST

56

27776

1

28961 ✓

39

39722

16

D3508-1RevC

Manufactured

No

260

Each

0.0000

1.0000



Wearplate

D3508-3RevC

Manufactured

No

260

Each

1.0000

1.0000



Wearplate

Warehouse
Location

Loc Qty

Loc Code

Main Warehouse

ST

1

46881

1

D3508-5RevC

Manufactured

No

260

Each

0.0000

1.0000



Wearplate

51261

2 BR 09-10-13.

1 BR 09-10-13.

1 BR 09-10-13.

1 BR 09-10-13

Picklist Print

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Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
D3508-7RevC		Manufactured	No			260	Each	1.0000	1.0000			
												
Wearplate												

Warehouse Loc Qty Loc Code

Location

Main Warehouse

ST 51389

44518

1

1

1 BR 09-10-13.

D3558-1RevB

Manufactured No



Gasket

260

Each

23.0000

1.0000



Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST

50925

23

23

1 BR 09-10-13

D3558-3RevB

Manufactured No



Gasket

260

Each

18.0000

1.0000



Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST

45661

51391

18

6

12

1 BR 09-10-13.

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Comments:

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Required Date: 9/17/2009


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Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
D3558-5RevB  Gasket		Manufactured	No			260	Each	14.0000	1.0000			


<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
<u>Location</u>		
Main Warehouse		
ST	14	
50926 ✓	14	

1 BR 09-10-13.

D3558-7RevB  Gasket		Manufactured	No			260	Each	21.0000	1.0000			
---	--	--------------	----	--	--	-----	------	---------	--------	--	--	--

<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
<u>Location</u>		
Main Warehouse		
ST	21	
36388	2	
43245	5	
50927 ✓	14	

1 BR 09-10-13.

NAS1611-007  O-RING		Purchased	No			260	Each	447.0000	1.0000			
---	--	-----------	----	--	--	-----	------	----------	--------	--	--	--

<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
<u>Location</u>		
Main Warehouse		
ST	447	
103697	447	

N/A O-Ring was already installed on the plug → older batch of plug.

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Work Order ID: 51777

Parent Item: D135-751-011RevC

Parent Item Name: Skidtube Installation



Comments:

Start Date: 9/3/2009

Required Date: 9/17/2009

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
NAS1611-010		Purchased	No			260	Each	345.0000	1.0000			
												
O-RING												

Warehouse Loc Qty Loc Code

Location

Main Warehouse

ST

345

110715 ✓

50

110915

295

4 BR 09-10-13.

NAS1611-013

Purchased

No

260

Each

320.0000

1.0000



O-RING



Warehouse Loc Qty Loc Code

Location

Main Warehouse

ST

320

106513

11

111424 ✓

109

111758 ✓

200

4 BR 09-10-13

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Shop Packet Print

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Picklist Print

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Thursday, September 03, 2009 8:11:23 AM

Work Order ID: 51777

Parent Item: D135-751-011RevC

Parent Item Name: Skidtube Installation

Comments:


Start Date: 9/3/2009

Required Date: 9/17/2009

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	--------------------------	---------------	----------------	--------

AN3C4A  BOLT		Purchased	No			280	Each	210.0000	8.0000			
--	--	-----------	----	--	--	-----	------	----------	--------	--	--	--

M112794 *CE*

Warehouse Location	Loc Qty	Loc Code
-----------------------	---------	----------

Main Warehouse

FP	-44	
----	-----	--


112314	-44	
--------	-----	--

Main Warehouse

ST	254	
----	-----	--

112082	14	
--------	----	--

112314	240	
--------	-----	--

AN960C10L  washer		Purchased	No			280	Each	2,500.000	8.0000			
---	--	-----------	----	--	--	-----	------	-----------	--------	--	--	--

9/10/10

Warehouse Location	Loc Qty	Loc Code
-----------------------	---------	----------

OFFSHORE

FG	100	
----	-----	--

103585	100	
--------	-----	--

Main Warehouse

FP	-44	
----	-----	--

112116	-44	
--------	-----	--

Main Warehouse

ST	2444	
----	------	--

112116	2444	
--------	------	--

M112116

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Thursday, September 03, 2009 8:11:23 AM

Work Order ID: 51777



Parent Item: D135-751-011RevC



Parent Item Name: Skidtube Installation

Start Date: 9/3/2009

Required Date: 9/17/2009

Comments:

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
D3506-1RevA Doubler		Manufactured	No			280	Each	3.0000	4.0000			

DP 9-10-8
B51789

Warehouse
Location
Main Warehouse
FG
46538

Loc Qty Loc Code

3

3

(2)

D3512-1RevC



Wearplate

Manufactured No

280

Each

3.0000

2.0000



B51390

EC 9/10/10 (1)

Warehouse
Location
Main Warehouse
ST500
51133

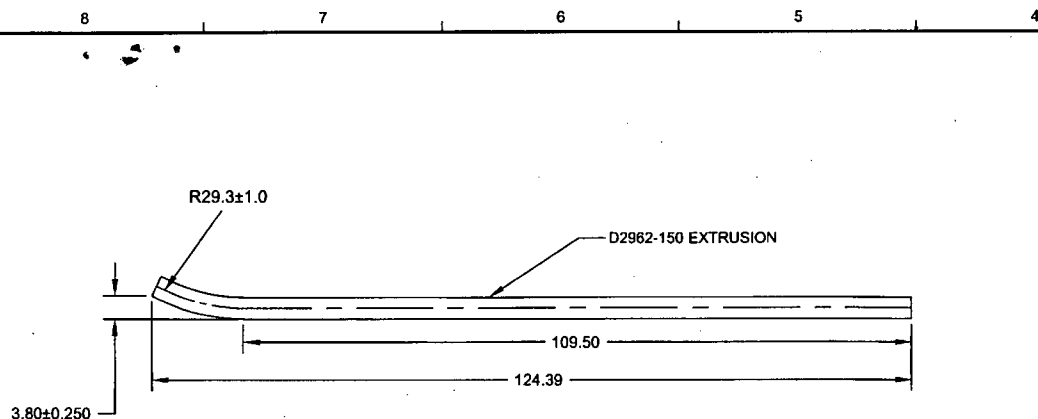
Loc Qty

Loc Code

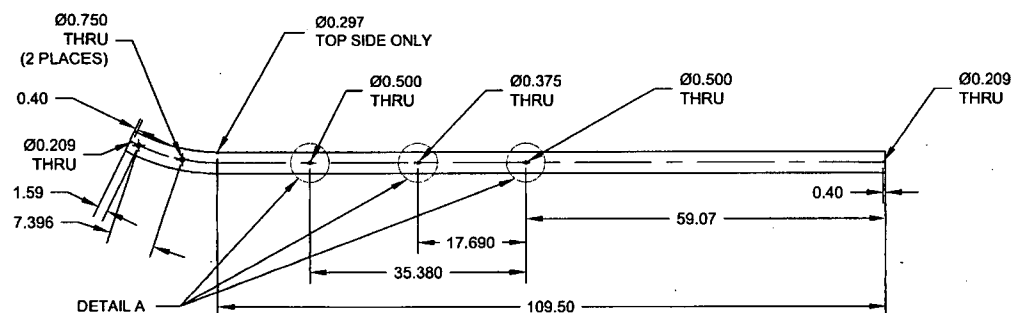
3

3

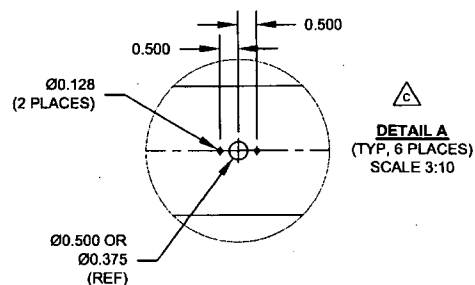
51778



D3507-1 BENDING/CUTTING DETAIL



D3507-1 DRILLING DETAIL

DETAIL A
(TYP, 6 PLACES)
SCALE 3:10

Qty	Part Number	Description
X	D3507-041	SKIDTUBE ASSEMBLY
1	D2962-150	EXTRUSION
1	D2965	CAP
1	D2965-3	CAP
4	D3492-041	PLUG ASSEMBLY
4	D3492-043	PLUG ASSEMBLY
2	D3492-047	PLUG ASSEMBLY
2	D3504-1	CROSS BOLT SPACER
1	D3504-3	CROSS BOLT SPACER
2	D3504-5	CROSS BOLT SPACER
1	D3505-1	WEB
4	D3506-1	DOUBLER
2	D3506-3	DOUBLER
1	D3508-1	WEARPLATE
1	D3508-3	WEARPLATE
1	D3508-5	WEARPLATE
1	D3508-7	WEARPLATE
1	D3558-1	GASKET
1	D3558-3	GASKET
1	D3558-5	GASKET
1	D3558-7	GASKET
38	AELS-1032-130	INSERT
1	AELS-1032-225	INSERT
31	AN3C4A	BOLT
2	AN3C5A	BOLT
2	AN526C1032-10	SCREW
33	AN960C10L	WASHER
12	MS20601AD4W3	RIVET

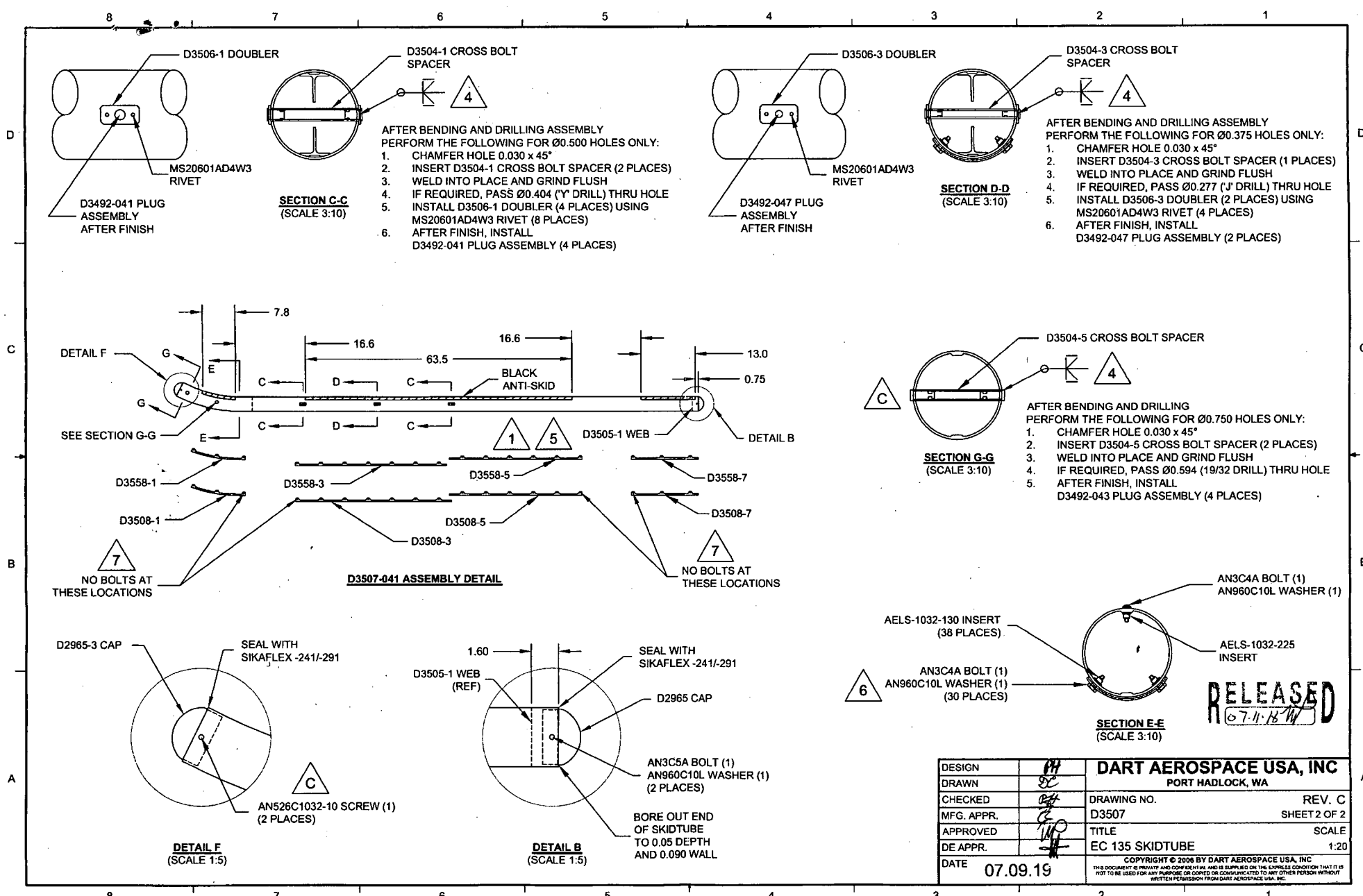
GENERAL NOTES:

- 1) FINISH:
CHEMICAL CONVERSION COAT PER DART QSI 005 4.1 PRIOR TO INSERTING D3505-1 WEB. POWDER COAT ASSEMBLY GLOSS WHITE (REF 4.3.5.1) PER DART QSI 005 4.3. ANTI-SKID PAINT AS INDICATED TO 1.00 ABOVE CENTER LINE PER DART QSI 005 4.4
- 2) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) DIMENSIONS: INCHES UNLESS OTHERWISE NOTED
- 4) WELDING TO BE DONE PER DART QSI 004
- 5) INSERT D3505-1 WEB TO LOCATION SHOWN OFF AFT END OF SKIDTUBE AND BOND WEB INTO OUTER TUBE WITH NON-STRUCTURAL SIKAFLEX-241/-291 ADHESIVE PER DART QSI 015 AFTER BENDING
- 6) USE DART DRILL TEMPLATE DT8868 TO LOCATE AND DRILL Ø0.297 HOLES (38 PLACES) FOR WEARSHOE INSERTS. INSTALL AELS-1032-130 PER SECTION C-C (38 PLACES) AFTER FINISH. SEAL WEARPLATE BOLTS WITH SIKAFLEX-241/-291.
- 7) DO NOT INSTALL AN3C4A BOLTS AND AN960C10L WASHERS IN INDICATED LOCATIONS

C	ADD D3504-5, FOR SKID GEAR DEFLECTOR; CHANGE FWD CAP BOLT TO AN526C1032-10 SCREW	DC	07.09.19
B	ADD GASKET, CHANGE HARDWARE MAT'L	PH	06.11.01
A	NEW ISSUE	PH	06.04.21
REV.	DESCRIPTION	BY	DATE
DESIGN	PH	DART AEROSPACE USA, INC PORT HADLOCK, WA	
DRAWN	JIC		
CHECKED	PH		
MFG. APPR.	PH		
APPROVED	PH		
DE APPR.	PH	DRAWING NO.	REV. C
		D3507	SHEET 1 OF 2
		TITLE	SCALE
		EC 135 SKIDTUBE	NTS
DATE	07.09.19	COPYRIGHT © 2006 BY DART AEROSPACE USA, INC THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.	

RELEASED
07-11-16-14

51778



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DRAWN	SC	PORT HADLOCK, WA	
CHECKED	PH	DRAWING NO.	REV. C
MFG. APPR.	PH	D3507	SHEET 2 OF 2
APPROVED	PH	TITLE	SCALE
DE APPR.	PH	EC 135 SKIDTUBE	1:20
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NO. 204

AWS D17.1.2001
QUALIFICATION TEST RECORD

Name: Barclay Elliott
Job number: 505370
Part number: D135 751 011
Description: Skid tube
Welding Process: Tig[☒] Mig[]
Base material: Aluminum
Current: AC[☒] DC[]

TEST REQUIREMENTS AND RESULTS

Visual: pass[☒] fail[]
Penetration: pass[☒] fail[]

UNACCEPTABLE

Cracks: pass[☒] fail[]
Undercut: pass[☒] fail[]
Pin holes: pass[☒] fail[]
Overlap (cold lap): pass[☒] fail[]
Porosity (surface): pass[☒] fail[]
Coloration: pass[☒] fail[]

Qualifier J. D. Durl Date of Test Coupon 09.07.16
Welder Barclay Elliott Date of Test Coupon 09/07/16

The above named individual is qualified in accordance with AWS D17.1.2001 to weld